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IS 746 (1987): Handloom cotton blankets, grey or coloured
[TXD 8: Handloom and Khadi]



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IS : 746 - 1987

Indian Standard
SPECIFICATION FOR
HANDLOOM COTTON BLANKETS,
GREY OR COLOURED
(*First Revision*)

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Indian Standard

**SPECIFICATION FOR
HANDLOOM COTTON BLANKETS,
GREY OR COLOURED**

(First Revision)

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Indian Standard
**SPECIFICATION FOR
HANDLOOM COTTON BLANKETS,
GREY OR COLOURED**
(First Revision)

0. FOREWORD

0.1 This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 11 May 1987, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

0.2 This standard was first published in 1955. It has been revised in order to make it up-to-date, with the following major changes:

- a) Two more varieties have been included; and
- b) Reference of latest versions of Indian Standards on test method have been specified.

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS: 2-1960*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of four varieties of handloom cotton blankets, grey or coloured.

1.2 This standard does not specify the type of finish, general appearance, lustre, feel or the colours and their combinations in coloured varieties of cloth.

*Rules for rounding off numerical values (revised).

2. MANUFACTURE

2.1 Yarn — The yarn used in the manufacture of cloth shall be such that the cloth produced complies with requirements of this standard.

2.2 Cloth — The cloth shall be raised on both sides and raising shall be of uniform density.

2.2.1 Each transverse end of the blanket shall be whipped or hem-stitched to a depth of not less than 2.5 cm, the raw edges having a turn in of 20 mm before the hem is formed. Cotton sewing thread conforming to variety number 31 of IS : 1720-1978* shall be used in hemming and the number of stitches shall be atleast 30 per decimetre.

2.2.2 If agreed to between the buyer and seller, three 20-mm wide red stripes at intervals of 20 mm, the first one being 18 cm away from transverse ends, shall be inserted.

3. REQUIREMENTS

3.1 The cloth of cotton blanket of a particular variety shall conform to constructional requirements as given in Table 1.

3.2 The cloth shall also conform to the requirements given in Table 2.

3.3 If in order to illustrate or specify the indeterminable characteristics such as general appearance, lustre, feel, and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

3.3.1 The custody of the sealed sample shall be matter of prior agreement between the buyer and the seller.

4. INSPECTION

4.1 The cloth, when visually inspected, should be reasonably free from the following defects:

- a) Weft crack or more than two missing picks across the width;
- b) Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, colour, shade, etc;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvedge defects;

*Specification for cotton sewing thread (*second revision*).

**TABLE 1 CONSTRUCTIONAL PARTICULARS OF HANDLOOM COTTON BLANKETS CLOTH;
GREY OR COLOURED**

(Clause 3.1)

VARI- ETY No.	COUNT OF YARN (FOR GUIDANCE ONLY)		ENDS PER DECI- METRE	PICKS PER DECI- METRE	WEIGHT PER BLANKET	BREAKING LOAD IN kg ON 10'0×20 cm STRIP (MINIMUM)		LENGTH	WIDTH	WEAVE
	Warp Tex (Cotton Count)	Weft Tex (Cotton Count)				Warp	Weft			
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)
1.	60 tex (10 ^s)	295 to 394 tex (or 1½ ^s to 2 ^s) soft spun waste yarn	80	60	gm 1 130	36	30	cm 230	cm 152	Plain/twill
2.	30 tex × 2(20 ^s /2)	295 to 394 tex (or 1½ ^s to 2 ^s) soft spun waste yarn	80	60	1 130	44	30	230	152	Plain/twill
3.	30 tex × 2(20 ^s /2)	295 to 394 tex (1½ ^s to 2 ^s) soft spun waste yarn	60	60	775	36	30	230	152	Plain/twill
4.	60 tex × 2(10 ^s /2)	295 to 394 tex (1½ ^s to 2 ^s) soft spun waste yarn	50	60	875	36	30	230	152	Plain/twill
TOLE- RANCE, PERCENT	—	—	±5	±5	±5	—	—	—1	—2	—
METHOD OF TEST	—	—	IS : 1963-1981*		see Appendix A	IS : 1969- 1985†	IS : 1954-1969‡		Visual	

*Determination of thread per unit length in woven fabrics (second revision).

†Determination of breaking load and elongation of woven textiles fabrics (second revision).

‡Determination of length and width of fabrics (first revision).

- e) Noticeable warp or weft float;
- f) Noticeable oil or other stains;
- g) Noticeable hole, cut or tear up to 3 mm in size;
- h) Smash rupturing the texture of the fabric; and
- j) Prominently noticeable dyeing defects (bars, streaks, patches, etc.)

TABLE 2 REQUIREMENTS OF HANDLOOM COTTON BLANKETS, GREY OR COLOURED

(Clause 3.2)

Sl. No.	CHARACTERISTICS	REQUIREMENTS	METHOD OF TEST
(1)	(2)	(3)	(4)
i)	Colour fastness ratings to (for dyed blankets only):		
a)	Light	4 or better	IS : 2454-1985* or IS : 686-1985†
b)	Washing : Test 4		IS : 765-1979‡
	1) change in colour	3 or better	
	2) staining on cotton	3 or better	
ii)	Scouring loss, percent, Max		IS : 1383-1977§
a)	Grey	10	
b)	Coloured	4	

*Colour fastness of textile material to artificial light (xenon lamp) (*first revision*).

†Colour fastness of textile material to daylight (*first revision*).

‡Colour fastness of textile material to washing (*second revision*).

§Determination of scouring loss in grey and finished cotton textile material (*first revision*).

4.1.1 A reference may be made to IS : 4125-1967* for details of these defects.

5. MARKING

5.1 The cloth shall be suitably marked or labelled with the following information:

- a) Name of the material and variety number;

*Glossary of terms pertaining to defects in fabrics.

- b) Manufacturer's name, initials or trade-mark;
- c) Month and year of manufacture; and
- d) Length and width of piece.

5.1.1 The cloth may also be marked with the standard Mark.

NOTE—The use of the Standard Mark is governed by the provisions of the Bureau of Indian Standards Act 1986 and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

6. PACKING

6.1 Unless otherwise agreed upon by the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS : 1347-1972* or IS : 293-1980†.

7. SAMPLING

7.1 The scale of sampling and criteria for conformity as given in IS : 3919-1966‡ shall be followed in respect of physical characteristics, namely, ends and picks, weight per blanket, breaking load, length and width.

7.2 The scale of sampling and criteria for conformity as given in IS : 5463-1969§ shall be followed in respect of the chemical characteristics of colour fastness and scouring loss.

APPENDIX A

(Table 1)

METHOD FOR DETERMINATION OF WEIGHT PER BLANKET

A-1. ATMOSPHERIC CONDITIONS FOR TESTING

A-1.1 The tests shall be carried out in a standard atmosphere at 65 ± 2 percent relative humidity and $27 \pm 2^\circ\text{C}$ temperature.

*Specification for inland packaging of cotton cloth and yarn (*first revision*).

†Code for seaworthy packaging of cotton yarn and cloth (*third revision*).

‡Methods for sampling cotton fabrics for determination of physical characteristics.

§Methods for sampling of cotton for chemical tests.

A-2. CONDITIONING OF TEST SPECIMENS

A-2.1 Prior to test, the test specimens shall be conditioned to moisture equilibrium in standard atmosphere at 65 ± 2 percent relative humidity and $27 \pm 2^{\circ}\text{C}$ temperature.

A-2.2 When the test specimens have been left in such an atmosphere for 24 hours in such a way as to expose as far as possible all portions of the test specimens to the atmosphere, they shall be deemed to have reached moisture equilibrium.

A-3. PROCEDURE

A-3.1 Measure the length and width of one test specimen correct to the nearest cm and determine the weight correct to the nearest 10 gm. Calculate the weight of the test specimen as per the dimensions specified in the Table 1.

A-3.2 Repeat the test with the remaining test specimens.

A-3.3 The mean of all values obtained as above shall be deemed to be the weight per blanket in the lot.

(Continued from page 2)

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INTERNATIONAL SYSTEM OF UNITS (SI UNITS)

Base Units

QUANTITY	UNIT	SYMBOL
Length	metre	m
Mass	kilogram	kg
Time	second	s
Electric current	ampere	A
Thermodynamic temperature	kelvin	K
Luminous intensity	candela	cd
Amount of substance	mole	mol

Supplementary Units

QUANTITY	UNIT	SYMBOL
Plane angle	radian	rad
Solid angle	steradian	sr

Derived Units

QUANTITY	UNIT	SYMBOL	DEFINITION
Force	newton	N	$1 \text{ N} = 1 \text{ kg.m/s}^2$
Energy	joule	J	$1 \text{ J} = 1 \text{ N.m}$
Power	watt	W	$1 \text{ W} = 1 \text{ J/s}$
Flux	weber	Wb	$1 \text{ Wb} = 1 \text{ V.s}$
Flux density	tesla	T	$1 \text{ T} = 1 \text{ Wb/m}^2$
Frequency	hertz	Hz	$1 \text{ Hz} = 1 \text{ c/s (s}^{-1}\text{)}$
Electric conductance	siemens	S	$1 \text{ S} = 1 \text{ A/V}$
Electromotive force	volt	V	$1 \text{ V} = 1 \text{ W/A}$
Pressure, stress	pascal	Pa	$1 \text{ Pa} = 1 \text{ N/m}^2$

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